

Work Order ID 130170

February-25-15 12:43:54 PM

130170

Page 1

Item ID: D3152-4

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Seal

Stop

NS2

Start Date: 2/25/15

Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/06/15

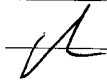
Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: 

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3152

C

110

0.00

110

Thermoform

Thermoforming Machine

Memo

0.00

1- FABRICATE AS PER DWG USING TOOL DT10106 BY INJECTING
SILICONE CASTING RESIN M-SILCC-65A (MCMaster CARR
P/N:8595K77) BATCH: M131112.
INSERT MOLD IN PRESSURE POT.

DAS

07

9-89

~~x6~~

15/03/15

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

FORM AS PER MOLD.

DAS

07

9-89

~~x6~~

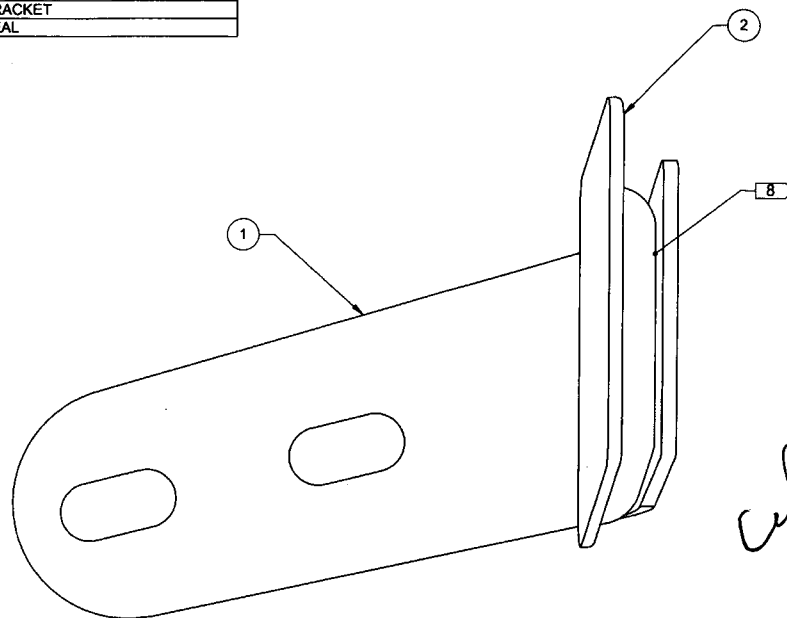
15/03/15

Page 2

15/03/25

15/3/27 JF
ME
15-3-26

ITEM	QTY .041	P/N	DESCRIPTION
	X	D3152-041	BRACKET ASSY
1	1	D3152-1	BRACKET
2	1	D3152-3	SEAL



W/O 130170

D3152-041 BRACKET ASSEMBLY

RELEASED

2015 FEB 13

ECN 14-663 97

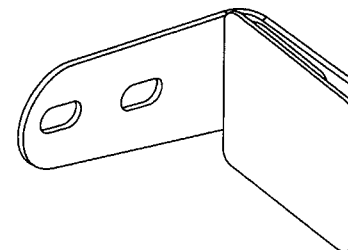
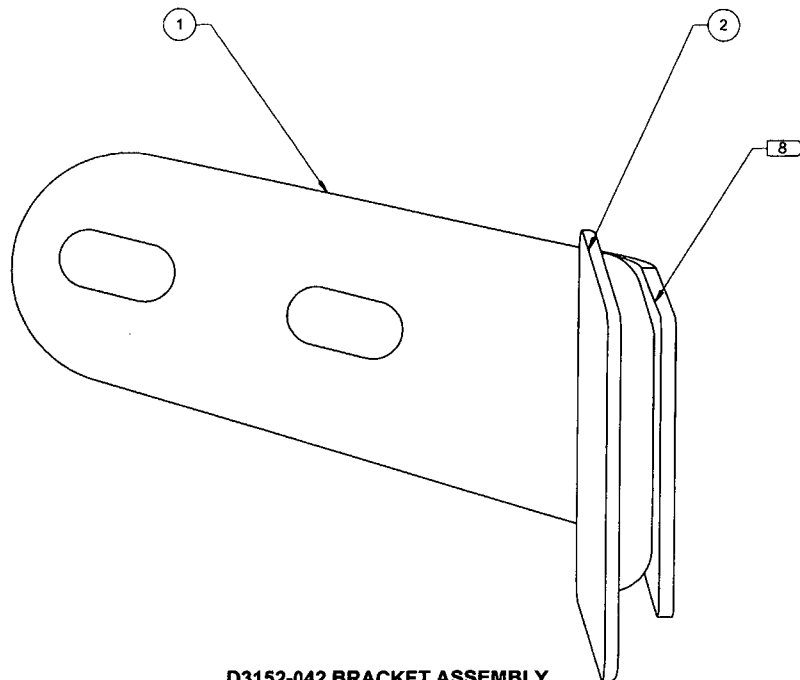
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) BOND D3152-3 SEAL TO D3152-1 BRACKET USING RTV 732 CLEAR (A/R) OR RTV 732 BLACK (A/R)

C	REVISE D3152-3/4 (MATERIAL), RE-FORMAT DRAWING, RE-DIMENSION D3152-1F	DB	14.10.28
B	ADD PART MARKING & RTV 732 BLACK	RF	04.10.18
A	NEW ISSUE	HS	02.04.24
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3152	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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APPROVED

ITEM	QTY -042	P/N	DESCRIPTION
	X	D3152-042	BRACKET ASSY
1	1	D3152-2	BRACKET
2	1	D3152-4	SEAL



D3152-042 BRACKET ASSEMBLY

RELEASED

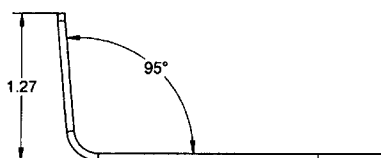
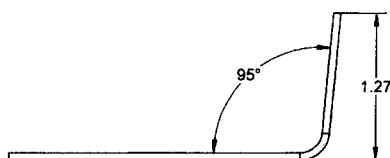
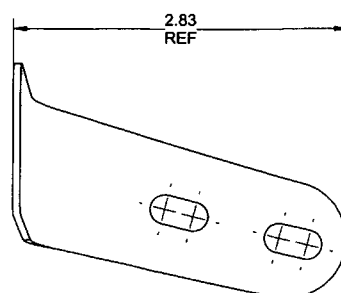
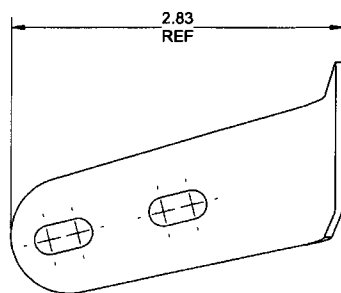
2015 FEB 13 *qf*

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) BOND D3152-4 SEAL TO D3152-2 BRACKET USING RTV 732 CLEAR (A/R) OR RTV 732 BLACK (A/R)

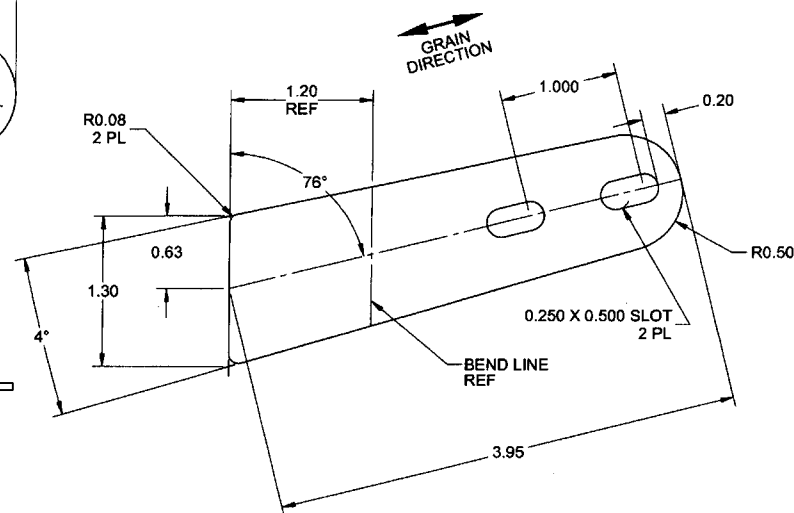
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DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3152	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS-#	BRACKET ASSEMBLY	NTS
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D3152-1 BRACKET
(MAKE FROM D3152-1F)
(REPLACES PREMIER P/N B30-23000-223)

D3152-2 BRACKET
(MAKE FROM D3152-1F)
(REPLACES PREMIER P/N B30-23000-224)



D3152-1F BRACKET
(FLAT PATTERN)

RELEASED

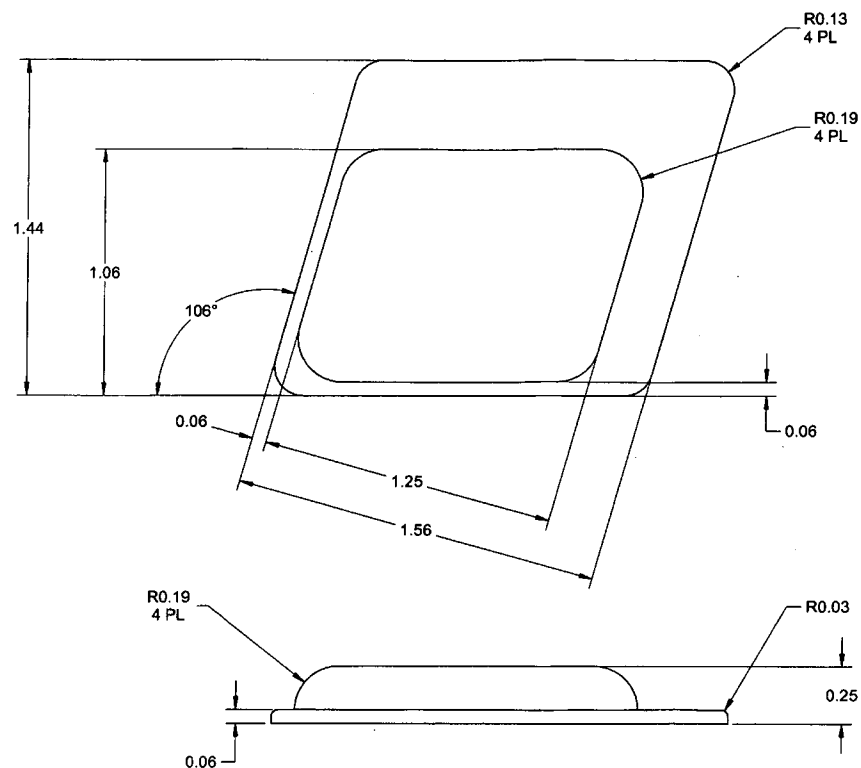
2015 FEB 13

NOTES:

- 1) MATERIAL: D3152-1F: 2024-T3 ALUMINIUM SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 PER DART SPEC M2024T3S.063
- 2) FINISH: D3152-1/2: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3152	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
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D3152-3 SEAL
(REPLACES PREMIER P/N B30-23000-243)

RELEASED

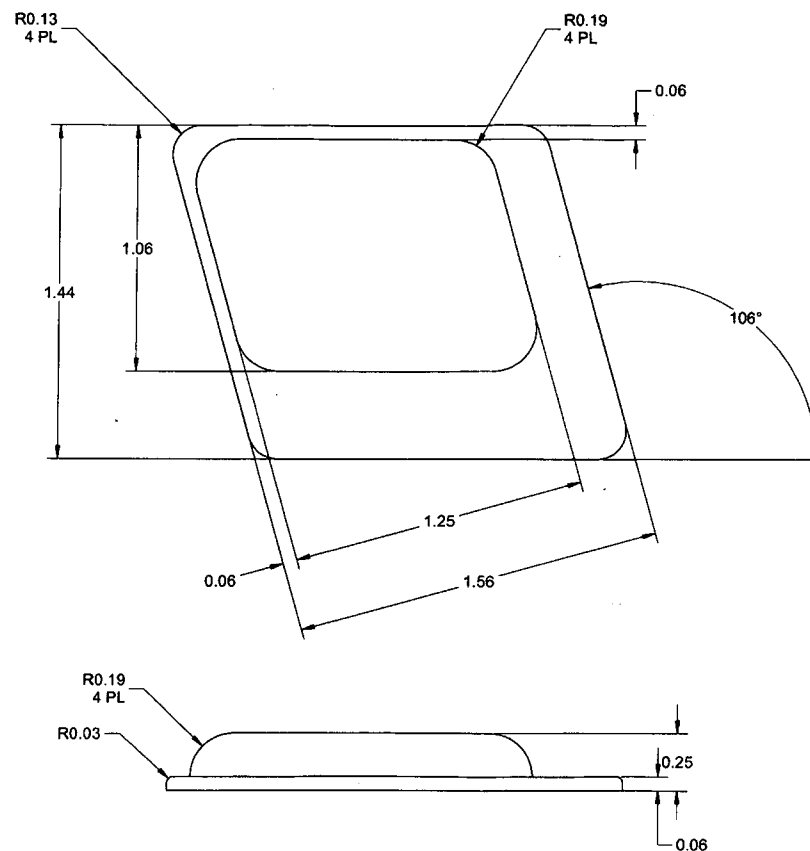
2015 FEB 13

NOTES:

- 1) MATERIAL: M-SILCC-65A (2 PART SILICONE CASTING RESIN, SHORE 65A)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.02 lbs
- 8) MAKE PARTS USING TOOL # DT10106 AND QSI 006 SECTION 4.18

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3152	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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D3152-4 SEAL
(REPLACES PREMIER P/N B30-23000-244)

RELEASED

2015 FEB 13 *g*

NOTES:

- 1) MATERIAL: M-SILCC-65A (2 PART SILICONE CASTING RESIN, SHORE 65A)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.02 lbs
- 8) MAKE PARTS USING TOOL # DT10106 AND QSI 006 SECTION 4.18

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3152	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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DART AEROSPACE LTD	Work Order:	130170
Description: <i>Seal</i>	Part Number:	03152-4
Inspection Dwg: <i>D3152-4 Rev: C</i>		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				

Not Applicable

Measured by:		Date:	
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.44"	$\pm 0.030"$	1.44"	✓			
1.06"	"	1.06"	✓			
1.25"	"	1.25"	✓			
1.56"	"	1.56"	✓			
0.06"	"	0.06"	✓			
0.25"	"	0.249"	✓			

Measured by:	<i>Wh</i>	Date:	15/03/16
Audited by:	<i>DAS</i> 38 9-89	Date:	MAR 26 2015
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	